

Date: Thursday, 4/12/2007 9:33:33 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PACKER
Job Number	: 31783		
Estimate Number	: 10225		
P.O. Number	: <i>N/A</i>	Part Number	: D2150
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2150 REV. A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 29837	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/28/2007 Qty: 20 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est C 00.11.27 Re-format (mpp 2101) EC Est Rev:D 06-08-23 Now on Waterjet JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 0.0263 sf(s)/Unit Total : 0.5250 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.040" thick  
(M2024T3S.040) Batch: *M104025*

*SAD*

*07/05/08*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2150  
Dwg Rev: *A*  
Prog Rev: *A*

*SAD*

*07/05/08 20*

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD*

*07/05/08*

*(20)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*07/05/08 20*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
Deburr

*x20*

*m/07/05/08*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/05/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:33:33 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PACKER

Job Number: 31783

Part Number: D2150

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL

07/05/09

(20)

7.0

POWDER COATING

POWDER COATING



M 103706



(20x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/05/09

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL

07/05/09

(20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: etc

PC 7/5/10 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

PC 7/5/10

Job Completion



U 07.05.10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>31783</b>
<b>Description: Packer</b>		<b>Part Number:</b>	<b>D2150</b>
<b>Inspection Dwg: D2150      Rev: A</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	0.747	✓		Vern	
2.050	+/-0.010	2.047	✓		Vern	
0.231	+/-0.010	0.233	✓		Vern	
1.217	+/-0.010	1.222	✓		Vern	
1.559	+/-0.010	1.568	✓		Vern	
2.300	+/-0.010	2.309	✓		Vern	
1.560	+/-0.010	1.567	✓		Vern	
0.250	+/-0.010	0.248	✓		Vern	
1.328	+/-0.010	1.331	✓		Vern	
0.342	+/-0.010	0.345	✓		Vern	
Ø0.098	+0.005/-0.000	Ø0.101	✓		Vern	
Ø0.171	+0.005/-0.000	Ø0.170	✓		Vern	
0.040	+/-0.010	0.040	✓		Vern	

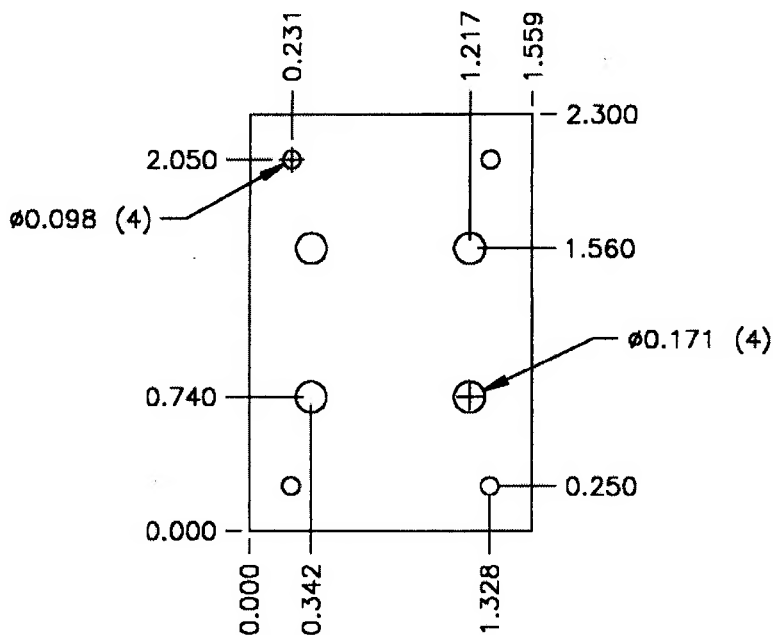
<b>Measured by:</b>	<b>SAD</b>	<b>Audited by:</b>	<b>[Signature]</b>	<b>Prototype Approval:</b>	<b>N/A</b>
<b>Date:</b>	<b>07/05/08</b>	<b>Date:</b>	<b>07/05/08</b>	<b>Date:</b>	<b>N/A</b>

Rev	Date	Change	Revised by	Approved
A	04.09.28	New Issue	KJ/JLM	[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	K HAND	DRAWING NO.	REV. A
CHECKED	APPROVED	D2150	SHEET 1 OF 1
DATE	TITLE	PACKER	SCALE
95:05:01			1:1

RELEASED  
96/06/13 BWS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31783

MATERIAL: 2024-T3, 0.040 THICK  
FINISH: WHITE POWDER COAT HI-GLOSS